

5106

DART AEROSPACE LTD	Work Order:	22190
Description: Prop Arm	Part Number:	D2730
Drawing: D2730 rev.B1	Qty:	20

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	JA	05.01.14	20
2	METAL	Punch 304/316 Seamless Tubing, 1/2" O.D. x 0.035" wall to length as per Dwg D2730 Batch <i>M17105</i>	AD	05.03.09	20
3	METAL	Drill as per dwg D2730 <i>MIC 219</i>	AB	05.03.09	20
4	METAL	Deburr	AB	05.03.09	20
5	QC	Inspect Level 5	Z	05.03.11	20
6	FINISHING	Powder coat white (Ref 4.3.5.2) per QSI 005 4.3	SG	05.03.18	20
7	QC	Inspect Level 3	MM	05.03.18	20
8	STORES	Identify and stock	CR	05.03.23	20
9	EXPEDITING	Close W/O Inspect level 21 Cost / part <i>11.97</i> Sur <i>05/03/20</i> (20) <i>10.97</i>	JA	05.04.05	20

Rev	Date	Change	Revised By	Approved
A		New issue (ipp-038)		
B	00.01.12	Re-format	EC	
C	00.07.07	Re-format, rev.B dwg (MPP 2074)	EC	
D	02.04.16	Added dwg Rev.B1	NG	<i>02-04-17</i>

RELEASED

02/04/16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

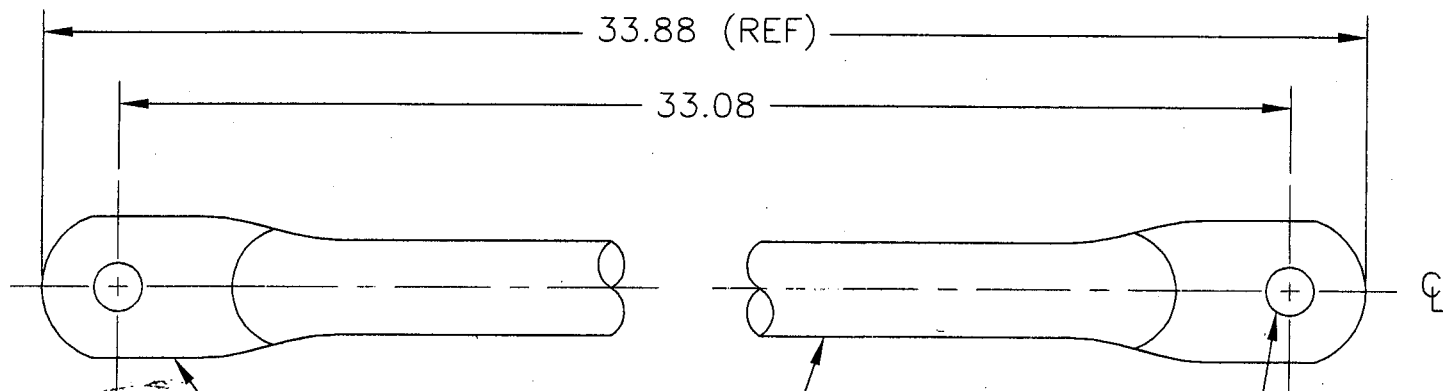
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2730	REV. B SHEET 1 OF 1
DATE 00.06.20		TITLE PROP ARM	SCALE NTS
A	98.04.20	NEW ISSUE	
B	00.06.20	33.88 WAS 33.25; 33.08 WAS 32.45	
B1	02.03.22	ADD FINISH	

RELEASED
00.06.27 #



PUNCH ENDS PER
SPEC CONTROL
DRAWING D2727

Ø0.50 TUBE (REF)

DRILL OUT ONE HOLE
USING 'Y' DRILL (Ø0.404)

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 22190

MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, Ø0.50 x 0.035 WALL
ENSURE SEAMLESS TUBE IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 05 4.3 \triangle B1

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 12, 2005
01:18 pm

Work Order No : 0022190
Project Name : D2730
Project For : WK506
Work Order Type : Main
Main WO Number :
House Part Number : D2730
Description : Door Prop
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 01-12-05
Est Finish Date : 02-05-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00